

Date: Friday, 11/17/2006 9:07:52 AM
 User: Kim Johnston

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD) |
| Job Number : 29510 | |
| Estimate Number : 10530 | |
| P.O. Number : <i>N/A</i> | Part Number : D2571 |
| This Issue : 11/17/2006 S.O. No. : <i>N/A</i> | Drawing Number : D2571 REV E |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <i>N/A</i> Type : MACHINED PARTS | Drawing Revision : E |
| Previous Run : 29159 | Material : <i>N/A</i> |
| Written By : <i>[Signature]</i> | Due Date : 12/5/2006 |
| Checked & Approved By : <i>[Signature]</i> | Qty: 16 Um: Each |
| Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----------|--------------------------|
| 1.0 | D6101007 | 7075-T7351 8.25X7.75X2.5 |
|-----|----------|--------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)
 7075-T7351 8.25X7.75X2.5
 Make from D6101-007 billet for D2571
 Ensure that grain is along 7.75" length
 Batch No: *B25353*

| | | |
|-----|-------|--------------------------------|
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. *29510* Double check by: *SD*

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets ✓
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets ✓
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

| | | |
|-----|---------------|------------------------------|
| 3.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|



Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572

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| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/12/19
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 11/17/2006 9:07:53 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 29510

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

3.1 06/12/10 16

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06/12/18

16x

7.0

POWDER COATING

POWDER COATING



M 10 2 3 9 1



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-R / a.m 06/12/10 16

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/12/19 16

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57971

06/14/19 16

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/19 16

Job Completion



C 06/12/19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|--|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 24510 |
| Description: Saddle, Fwd Outboard | Part Number: | D2571 |
| Inspection Dwg: D2571 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|-------------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | DT8682 | 0.440 | 0.440 | 0.440 | 0.440 | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| E | 7.990 | 8.010 | | 7.997 | 7.999 | 7.998 | 7.998 | | |
| F | 0.490 | 0.510 | | 0.496 | 0.503 | 0.502 | 0.502 | | |
| G | 0.257 | 0.262 | DT8683 | 0.258 | 0.258 | 0.258 | 0.258 | | |
| H | 0.375 | 0.380 | DT8684 | 0.377 | 0.376 | 0.376 | 0.376 | | |
| I | 0.490 | 0.510 | | 0.497 | 0.498 | 0.500 | 0.500 | | |
| J | 1.174 | 1.184 | | 1.179 | 1.178 | 1.178 | 1.179 | | |
| K | 0.558 | 0.578 | | 0.568 | 0.564 | 0.567 | 0.569 | | |
| L | 1.174 | 1.184 | | 1.179 | 1.178 | 1.178 | 1.179 | | |
| M | 1.490 | 1.500 | | 1.495 | 1.494 | 1.496 | 1.495 | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| O | 3.869 | 3.879 | | 3.874 | 3.872 | 3.872 | 3.872 | | |
| P | 0.115 | 0.135 | | 0.125 | 0.126 | 0.126 | 0.127 | | |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| R | 0.240 | 0.260 | | 0.250 | 0.251 | 0.251 | 0.251 | | |
| S | 0.115 | 0.135 | | 0.128 | 0.130 | 0.129 | 0.132 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 2.940 | 2.980 | | 2.959 | 2.966 | 2.961 | 2.961 | | |
| V | 0.230 | 0.250 | | 0.242 | 0.242 | 0.242 | 0.246 | | |
| W | 0.115 | 0.135 | | 0.123 | 0.129 | 0.129 | 0.130 | | |
| X | 0.308 | 0.313 | | 0.312 | 0.312 | 0.312 | 0.312 | | |
| Y | 0.760 | 0.765 | | 0.761 | 0.761 | 0.761 | 0.761 | | |
| Z | 0.352 | 0.372 | | 0.364 | 0.360 | 0.365 | 0.366 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.624 | 0.632 | 0.632 | 0.632 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.252 | 0.252 | 0.254 | 0.247 | | |
| AE | 1.375 | 1.395 | | 1.386 | 1.385 | 1.385 | 1.386 | | |
| AF | 0.115 | 0.135 | | 0.133 | 0.122 | 0.130 | 0.130 | | |
| AG | 0.240 | 0.280 | | 0.245 | 0.260 | 0.263 | 0.263 | | |
| AH | 0.240 | 0.260 | | 0.250 | 0.251 | 0.251 | 0.250 | | |
| AI | 2.000 | 2.020 | | 2.000 | 2.001 | 2.000 | 2.000 | | |
| AJ | 0.023 | 0.043 | | 0.033 | 0.033 | 0.033 | 0.033 | | |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|---------------------|
| Measured by: | <i>JD</i> |
| Date: | 06/11/24 / 06/11/27 |

| | |
|-------------|------------|
| Audited by: | <i>J.L</i> |
| Date: | 06/12/10 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

| | |
|--|---------------------------|
| DART AEROSPACE LTD | Work Order: 29510 |
| Description: Saddle, Fwd Outboard | Part Number: D2571 |
| Inspection Dwg: D2571 Rev. E | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|-------------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | DT8682 | 0.440 | 0.439 | 0.439 | 0.440 | | |
| B | 1.745 | 1.755 | | 1.756 | 1.750 | 1.748 | 1.750 | | |
| C | 3.495 | 3.505 | | 3.506 | 3.500 | 3.500 | 3.506 | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| E | 7.990 | 8.010 | | 7.998 | 7.998 | 7.999 | 7.998 | | |
| F | 0.490 | 0.510 | | 0.503 | 0.503 | 0.503 | 0.500 | | |
| G | 0.257 | 0.262 | DT8683 | 0.258 | 0.258 | 0.258 | 0.258 | | |
| H | 0.375 | 0.380 | DT8683 | 0.376 | 0.376 | 0.376 | 0.377 | | |
| I | 0.490 | 0.510 | | 0.499 | 0.499 | 0.500 | 0.498 | | |
| J | 1.174 | 1.184 | | 1.178 | 1.178 | 1.178 | 1.178 | | |
| K | 0.558 | 0.578 | | 0.567 | 0.567 | 0.566 | 0.565 | | |
| L | 1.174 | 1.184 | | 1.178 | 1.178 | 1.178 | 1.178 | | |
| M | 1.490 | 1.500 | | 1.497 | 1.495 | 1.494 | 1.494 | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.499 | 2.500 | | |
| O | 3.869 | 3.879 | | 3.874 | 3.872 | 3.872 | 3.873 | | |
| P | 0.115 | 0.135 | | 0.127 | 0.127 | 0.128 | 0.127 | | |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| R | 0.240 | 0.260 | | 0.251 | 0.251 | 0.251 | 0.251 | | |
| S | 0.115 | 0.135 | | 0.130 | 0.130 | 0.131 | 0.131 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 2.940 | 2.980 | | 2.960 | 2.960 | 2.960 | 2.960 | | |
| V | 0.230 | 0.250 | | 0.241 | 0.240 | 0.241 | 0.240 | | |
| W | 0.115 | 0.135 | | 0.126 | 0.127 | 0.127 | 0.127 | | |
| X | 0.308 | 0.313 | | 0.312 | 0.312 | 0.312 | 0.312 | | |
| Y | 0.760 | 0.765 | | 0.761 | 0.761 | 0.761 | 0.761 | | |
| Z | 0.352 | 0.372 | | 0.364 | 0.364 | 0.364 | 0.365 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.633 | 0.633 | 0.633 | 0.635 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.251 | 0.251 | 0.248 | 0.250 | | |
| AE | 1.375 | 1.395 | | 1.386 | 1.386 | 1.387 | 1.387 | | |
| AF | 0.115 | 0.135 | | 0.125 | 0.125 | 0.128 | 0.132 | | |
| AG | 0.240 | 0.280 | | 0.256 | 0.258 | 0.254 | 0.266 | | |
| AH | 0.240 | 0.260 | | 0.250 | 0.250 | 0.249 | 0.250 | | |
| AI | 2.000 | 2.020 | | 2.000 | 2.000 | 2.003 | 2.001 | | |
| AJ | 0.023 | 0.043 | | 0.036 | 0.036 | 0.036 | 0.036 | | |
| Accept/Reject | | | | | | | | | |

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|------------------------|
| Measured by: <i>mf</i> |
| Date: 06/11/27 |

| |
|------------------------|
| Audited by: <i>J.L</i> |
| Date: 06/10/12 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

| | | |
|--|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 29510 |
| Description: Saddle, Fwd Outboard | Part Number: | D2571 |
| Inspection Dwg: D2571 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | DT8682 | .439 | .439 | .439 | 0.446 | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.501 | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| E | 7.990 | 8.010 | | 7.995 | 8.000 | 8.000 | 8.002 | | |
| F | 0.490 | 0.510 | | .498 | .495 | .496 | 0.501 | | |
| G | 0.257 | 0.262 | DT8683 | .258 | .258 | .258 | 0.258 | | |
| H | 0.375 | 0.380 | DT8684 | .376 | .376 | .376 | 0.377 | | |
| I | 0.490 | 0.510 | | .499 | .499 | .499 | 0.499 | | |
| J | 1.174 | 1.184 | | 1.179 | 1.175 | 1.179 | 1.175 | | |
| K | 0.558 | 0.578 | | .566 | .567 | .568 | 0.564 | | |
| L | 1.174 | 1.184 | | 1.179 | 1.175 | 1.179 | 1.175 | | |
| M | 1.490 | 1.500 | | 1.493 | 1.493 | 1.493 | 1.492 | | |
| N | 2.495 | 2.505 | | 2.500 | 2.508 | 2.500 | 2.495 | | |
| O | 3.869 | 3.879 | | 3.874 | 3.874 | 3.874 | 3.872 | | |
| P | 0.115 | 0.135 | | .126 | .127 | .127 | 0.172 | | |
| Q | 0.115 | 0.135 | | .135 | .135 | .135 | 0.135 | | |
| R | 0.240 | 0.260 | | .250 | .257 | .251 | 0.251 | | |
| S | 0.115 | 0.135 | | .130 | .129 | .129 | 0.126 | | |
| T | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | | |
| U | 2.940 | 2.980 | | 2.960 | 2.960 | 2.960 | 2.962 | | |
| V | 0.230 | 0.250 | | .240 | .240 | .238 | 0.238 | | |
| W | 0.115 | 0.135 | | .125 | .122 | .123 | 0.124 | | |
| X | 0.308 | 0.313 | | .311 | .311 | .311 | 0.310 | | |
| Y | 0.760 | 0.765 | | .761 | .761 | .761 | 0.765 | | |
| Z | 0.352 | 0.372 | | .363 | .363 | .363 | 0.361 | | |
| AA | 0.470 | 0.530 | | .500 | .500 | .500 | 0.500 | | |
| AB | 0.615 | 0.635 | | .624 | .624 | .623 | 0.629 | | |
| AC | 0.053 | 0.073 | | .063 | .063 | .063 | 0.063 | | |
| AD | 0.240 | 0.260 | | .250 | .248 | .248 | 0.247 | | |
| AE | 1.375 | 1.395 | | 1.386 | 1.387 | 1.389 | 1.387 | | |
| AF | 0.115 | 0.135 | | .134 | .134 | .134 | 0.135 | | |
| AG | 0.240 | 0.280 | | .250 | .250 | .257 | 0.260 | | |
| AH | 0.240 | 0.260 | | .249 | .248 | .248 | 0.248 | | |
| AI | 2.000 | 2.020 | | 2.001 | 2.002 | 2.003 | 2.002 | | |
| AJ | 0.023 | 0.043 | | .033 | .033 | .033 | 0.030 | | |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|---------------------|
| Measured by: | SD / En |
| Date: | 06.11.28 / 06.11.29 |

| | |
|-------------|----------|
| Audited by: | JL |
| Date: | 06/12/10 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

| | | |
|--|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 29510 |
| Description: Saddle, Fwd Outboard | Part Number: | D2571 |
| Inspection Dwg: D2571 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|-------------------|----------------------------|-------|-------|-------|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | DT8682 | 0.440 | 0.440 | 0.440 | 0.440 | | |
| B | 1.745 | 1.755 | | 1.749 | 1.750 | 1.751 | 1.746 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.749 | 1.750 | 1.751 | 1.746 | | |
| E | 7.990 | 8.010 | | 8.002 | 8.003 | 8.003 | 8.003 | | |
| F | 0.490 | 0.510 | | 0.500 | 0.500 | 0.500 | 0.499 | | |
| G | 0.257 | 0.262 | DT8683 | 0.259 | 0.259 | 0.259 | 0.259 | | |
| H | 0.375 | 0.380 | DT8684 | 0.377 | 0.377 | 0.377 | 0.377 | | |
| I | 0.490 | 0.510 | | 0.500 | 0.499 | 0.498 | 0.502 | | |
| J | 1.174 | 1.184 | | 1.175 | 1.176 | 1.176 | 1.176 | | |
| K | 0.558 | 0.578 | | 0.566 | 0.565 | 0.562 | 0.566 | | |
| L | 1.174 | 1.184 | | 1.175 | 1.176 | 1.176 | 1.176 | | |
| M | 1.490 | 1.500 | | 1.493 | 1.493 | 1.494 | 1.495 | | |
| N | 2.495 | 2.505 | | 2.498 | 2.500 | 2.499 | 2.497 | | |
| O | 3.869 | 3.879 | | 3.872 | 3.872 | 3.873 | 3.870 | | |
| P | 0.115 | 0.135 | | 0.127 | 0.127 | 0.126 | 0.126 | | |
| Q | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| R | 0.240 | 0.260 | | 0.252 | 0.251 | 0.251 | 0.251 | | |
| S | 0.115 | 0.135 | | 0.129 | 0.128 | 0.129 | 0.129 | | |
| T | 0.178 | 0.198 | | 0.188 | 0.188 | 0.188 | 0.188 | | |
| U | 2.940 | 2.980 | | 2.964 | 2.960 | 2.960 | 2.960 | | |
| V | 0.230 | 0.250 | | 0.235 | 0.237 | 0.240 | 0.239 | | |
| W | 0.115 | 0.135 | | 0.122 | 0.123 | 0.123 | 0.123 | | |
| X | 0.308 | 0.313 | | 0.310 | 0.310 | 0.311 | 0.310 | | |
| Y | 0.760 | 0.765 | | 0.765 | 0.765 | 0.765 | 0.765 | | |
| Z | 0.352 | 0.372 | | 0.362 | 0.365 | 0.362 | 0.362 | | |
| AA | 0.470 | 0.530 | | 0.500 | 0.500 | 0.500 | 0.500 | | |
| AB | 0.615 | 0.635 | | 0.628 | 0.627 | 0.628 | 0.628 | | |
| AC | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | | |
| AD | 0.240 | 0.260 | | 0.245 | 0.250 | 0.246 | 0.246 | | |
| AE | 1.375 | 1.395 | | 1.388 | 1.387 | 1.386 | 1.387 | | |
| AF | 0.115 | 0.135 | | 0.135 | 0.135 | 0.135 | 0.135 | | |
| AG | 0.240 | 0.280 | | 0.260 | 0.260 | 0.260 | 0.260 | | |
| AH | 0.240 | 0.260 | | 0.248 | 0.247 | 0.248 | 0.248 | | |
| AI | 2.000 | 2.020 | | 2.002 | 2.002 | 2.001 | 2.002 | | |
| AJ | 0.023 | 0.043 | | 0.030 | 0.030 | 0.030 | 0.030 | | |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|---------------------|
| Measured by: | SD / E |
| Date: | 06.11.28 / 06/11/29 |

| | |
|-------------|----------|
| Audited by: | J.L |
| Date: | 06/12/10 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.24 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

05.12.06

MATERIAL: 7075-17351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

$\triangle E$

| | | |
|------------------|----------------|--|
| E | 05.07.13 | ADD CHAMFER ON RIDGE, NOTE 5 |
| D | 02.09.06 | ADD RIDGES; TIGHTEN TOLERANCES |
| C | 99.10.22 | INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177 |
| B | 96.12.02 | ADD GRAIN DIR., 0.438 WAS 0.425 |
| A | 96.09.16 | NEW ISSUE |
| DESIGN DS | DRAWN BY PH | DART DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, ENGLAND |
| CHECKED # | APPROVED # | DRAWING NO. D2571 |
| DATE 05.07.13 | | TITLE OUTER FWD SADDLE |

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DETAIL C
SCALE 4:3

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